		1707 DE	160,									
Work Orden November 23, 200												Page
Item ID:	02230-3			A	Accept				ll s	etup Stai	-t	
Revision ID:	3								2011 1261	S to	# ####################################	
Item Name:	Lug							•		Sto		
Start Date: 2	23/11/2009	Start Qty: 10	00.00			Cust Item II):					
Required Date: 2	27/11/2009	Req'd Qty: 10	00.00			Customer:		ir.e				
Reference:								Ċ				
Approvals:	Process Pla	in: As	Date	9211-23	Tooling:	Da	te:		R	Run Sta	rt	
• •	QC:	···· , ///	Date:	•	SPC (Y/N):	Da				Sto	Р	
Sequence ID/ Work Center ID)	Operation Description			Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr										
D2230	Rev	/ G				' :,		ļ				
100 Bandsaw		BAND SAW	o		0.00	22 Ant 04	2/12/0		_100			_
Jeaspa Bandsaw		Band	Saw □Cut D24	23 extrusion to 0.8	2" □Batch: <u> 93 <i>{</i></u>						e.	
110 HAAS 1		HAAS CNC VER			0.00	FF09/12/	64		109-	Ø	· ·	
HAAS CNC vertical	machine #1	Mach	nne per folio D2	230-3□Check for	crack while loading ir	to the machine.						

120 QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Dart Aerospace Ltd	Dart	Aer	osp	ace	Ltd
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W/O:			WO	ORK ORDER CHANG	ES .			·	•
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	r								
	:								
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	· · · · · · · · · · · · · · · · · · ·	Corrective Action Section		Verifi	cation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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	i .	,							
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1									

Item ID:

D2230-3

G **Revision ID:** Item Name: Lug

Required Date: 27/11/2009

Start Date:

23/11/2009

Start Oty: 100.00 Rea'd Otv: 100.00



Accept

Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan: Date:

QC: Date:

SPC (Y/N):

Date

Draw

Date

Run

Start

Stop

Setup Start

Stop



Sequence ID/ Work Center ID

130

Quality Control

Operation Description

OC8- Inspect parts - second check

Memo

Set Up/ Run Hours

0.00

Tooling:

0.00 and oglialor

Number Rev. Code

Plan Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

Small Fab

Small Fab

Small Fab

Memo

Tumble and deburr rough edges after tumbling

0.00

0.00

100 0

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

MD 09/12/07

X100

Hand Finishing

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									, ten
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCI	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
	JOIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	ion C	Chief Eng	QC Inspector
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		,							
									

W٥	rk C	rder	· ID	53881
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Page 3

November 23, 2009 11:21:30 AM

G

Item ID:

D2230-3

Revision ID: Item Name:

Lug

23/11/2009

Required Date: 27/11/2009

Start Qty: 100.00 Req'd Qty: 100.00



Cust Item ID:

Customer:

Date:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Accept

SPC (Y/N):

Date:

Run

Start

Stop

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

Draw Number

Draw Rev.

Plan Code

Accept Qty.

Reject Qty

Setup Start

Reject Insp. Number Stamp

170

Powdercoat

Powder Coating

White Gloss(Ref: 4.3.5.1) per QSI005 4.3-Alum M//Q/4/S

0.00

Memo START TIME:

OVEN TEMPERATURE:

0.00

180

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00 =) HO 09/02/08

Bl09-12-8

Dart Aerospace Ltd

W/O:			V	WORK ORDER C	HANGES				•	
DATE	STEP	PRO	OCEDURE CI	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			•						<u>,</u>	
Part No	•	PAR #:	Fault Ca	ntegory:	NC	R: Yes I	No DQ	1	Date:	
		esolution:								
NCR:			WORK OR	DER NON-CON	ORMANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action		0: 0	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Desc Chief En		Sign & Date	Section	on C	Chief Eng	QC Inspector
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							1			

Work Order ID 53881



Page 4

November 23, 2009 11:21:30 AM

G

Required Data: 27/11/2009

Lug

Item ID:

D2230-3

Accept

Setup Start

Stop



Revision ID: Item Name:

Start Date: 23/11/2009

Start Qty: 100.00

Req'd Qty: 100.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

QC:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run

Start

Stop

Sequence ID/ **Work Center ID**

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 51 476

Date:

0.00

mo 09/12/08

Draw

Number

0.00

Draw

Rev.

Code

Plan

Accept Qty

SOLK

Reject Qty

Reject Number Stamp

Insp.

200

QC

Quality Control

OC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

Dart	Aeros	pace	Ltd
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	•									
W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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										}
Part No	:	PAR #:	Fault Cate	gory:	_ NCR	: Yes I	No DQ	A :	_ Date: _	
		esolution:								
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)	-		
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
									:	

November 23, 2009 11:21:36 AM

Work Order ID: 53881

Parent Item:

D2230-3RevG

Parent Item Name: Lug

Comments:





Start Date: 23/11/2009

Required Date: 27/11/2009

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-3PRevF		Purchased A	No M	= 09-	12-08	100	Each	0.0000	100.0000			<i>.</i>
LUG D2423RevB1		Manufactured	No			100	f	642.3871	7.1895			

Lug Extrusion

<u>Warehouse</u>	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	642.3870800	
₹ 43722	191.446248	
44529	22.39	
45800	428.550832	

7.1895 onlog/2/01

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES		,		
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		-							
		API,							
Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	_ Date: _	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section			cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	53881
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Artic	e Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments	
Dimension		Dimension		Nejout	Inspection		
4.450	+/-0.010	4,451					
0.413	+/-0.010	0.415					
0.306	+/-0.010	0.308				`)	
3.700	+/-0.010	3,700					
0.750	+/-0.010	0,749	/,				
Ø0.257	+0.005/-0.000	0.261					
0.375	+/-0.010	0.375					
R1.200	+/-0.010	1.200	/ ,_				
0.100 x 45°	+/-0.010	0,100x45°					
0,273	7-0,010	0.273					
		·					
					_		
	٠.						
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			•
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 69/12/04	Date: 09/12/07	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue	KJ/RF O	· 4

D2230-1

D2230-1 MOUNTING LUG

SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER, NO. 5358/ Bl09-11-23 D2230-3

D2230-3 MOUNTING LUG



SHORAGIN REEL OF 1 ENGINE NO 5 UNCONTROLLED CO. Y

DECICA	DIA/	D 4 DT 4 FD 0 CD 4	OF 13	
REV.	DESCRIPTION		BY	DATE
С	RE-DESIGN			94.03.30
D	RE-DESIGN			95.01.04
E	RE-DESIGN		BW	95.01.04
F	REDESIGN; R1.200 WAS 1.100			99.12.13
G	STANDARDS, REFER T	DRKS TO CURRENT DESIGN O SECTION A-A & B-B FILLET HAFING OF RUBBER CUSHION ON	AJS	09.01.16

	DESIGN	ву	DART AEROSPACE LTD		
	DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
	CHECKED	1	DRAWING NO.	REV. G	
	MFG. APPR.	Cod .	D2230	SHEET 1 OF 3	
	APPROVED	(M)	TITLE	SCALE	
į	DE APPR.	'-H	MOUNTING LUG	NTS	
i	DATE 09.0	1.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT AND DOMPDENTIAL AND IS DUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPLIES ON CONFIDENCE TO JET ONLY OTHER PURSON WITHOUT		

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ±0.005

OF 0.015±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs



